

Work Order ID **77302**

77302

Page 1

December 2, 2011 8:52:09 AM

Item ID: D350-604-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rear Locker Extender

Start Date: 12/02/11 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/23/11 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: CL Date: 11/12/02 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2273	D
D350-604-041	A
DSI9470	A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-604-041 CHG002

5 12/01/23

MLJ 12-1-20

110

0.00

110

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 15600

Description: D350-604-041 Rear locker extender.

Supplier: Delastek.

Certification of Conformity and process sheet from Delastek is required.

4 x 2600-6 Camlock stud - Ship to Delastek B 118852

CL 11/12/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

77302

December 2, 2011 8:52:09 AM

N900040100

Setup Start ***NS1***

Stop *NS2*

Start Date: 12/02/11 **Start Qty:** 1.00 ***1***

Required Date: 12/23/11 **Req'd Qty:** 1.00 *** 1 ***

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 77302

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December 2, 2011 8:52:09 AM

Item ID: D350-604-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Rear Locker Extender

Stop ***NS2***

Start Date: 12/02/11 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/23/11 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC4- 100% Inspect kits for completeness	0.00							
150									
QC	Memo	0.00							
Quality Control									
160		0.00							
160	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-604-041								
	Location: _____								
	PPP Rev: <u> </u>								
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

8/21/123

sp 12-01-23

12/1/24

12/12-01-24
H

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 2, 2011 8:52:09 AM

Page 1

Work Order ID: 77302

Parent Item: D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 12/02/11

Required Date: 12/23/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:Q03.12.01ReformatKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2600-6 Camlock Stud		Purchased	No			110	Each	111.0000	4			12/11/12/06	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST380		111							
				118611		1							
				118800		20							
				118852		90							
D350-604-041P Rear Locker Extender		Purchased	No			120	Each	0.0000	1			77302	
D2268 Decal		Manufactured	No			140	Each	13.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST009		13							
				69592		2							
				74520		11							
D2269 Decal		Manufactured	No			140	Each	9.0000	1			12/10/13	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST009		9							
				74521		9							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

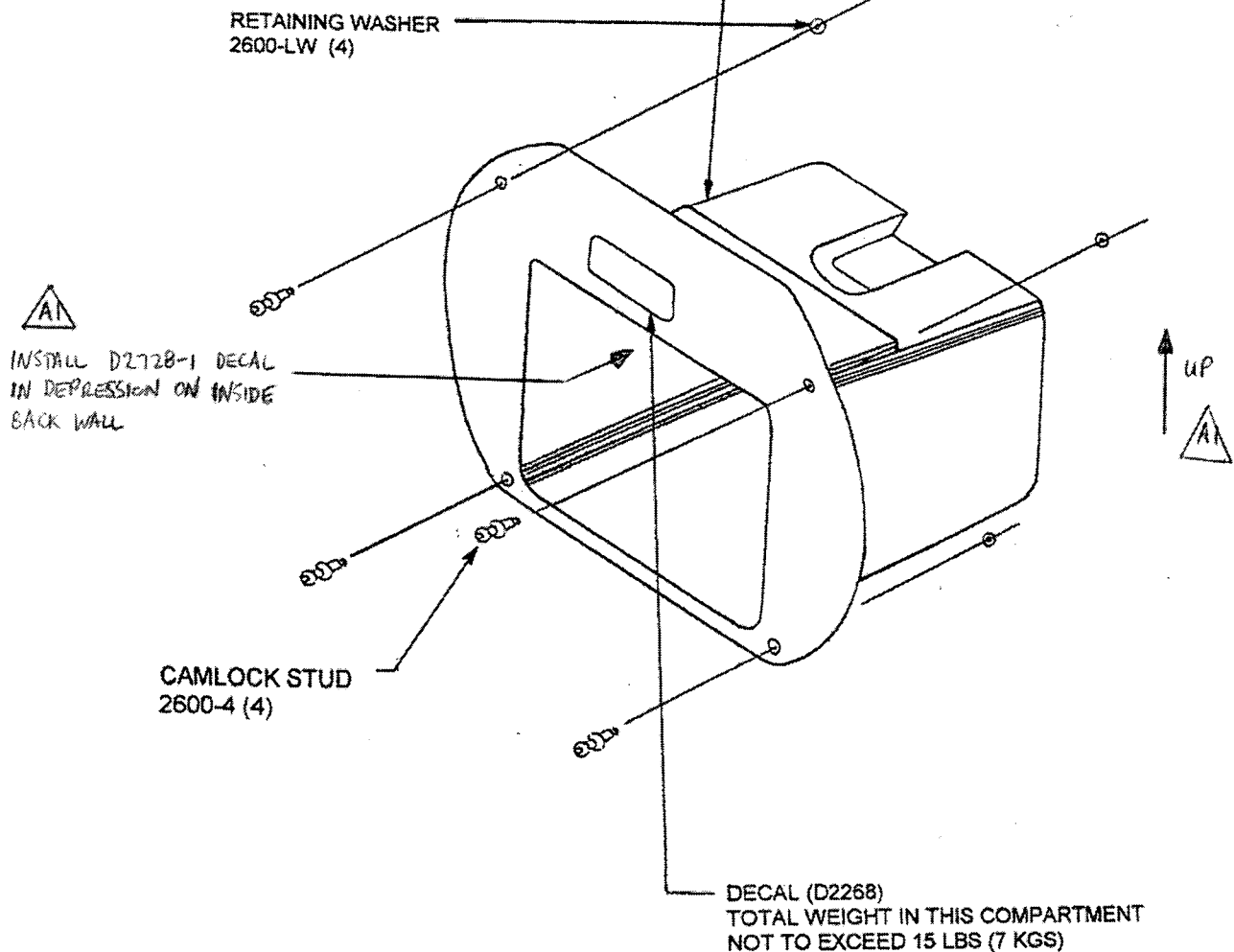
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D350-604-041	REV. A SHEET 1 OF 1
DATE 02.04.01		TITLE REAR LOCKER EXTENDER ASSEMBLY	SCALE NTS
A	02.04.01	NEW ISSUE	
AI	RF 02.04.23	ADD D2728-1 DECAL + ORIENTATION NOTE	

RELEASED
02.04.03 [Signature]



D350-604-041 REAR LOCKER EXTENDER

NOTE: DECALS TO BE ORIENTED TO MATCH 'UP' ORIENTATION OF RLE



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

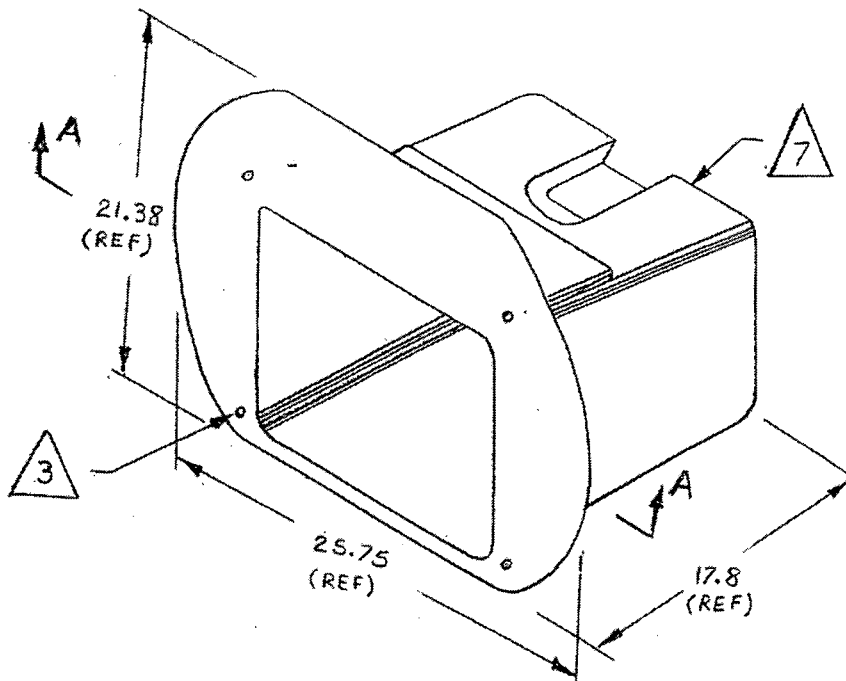
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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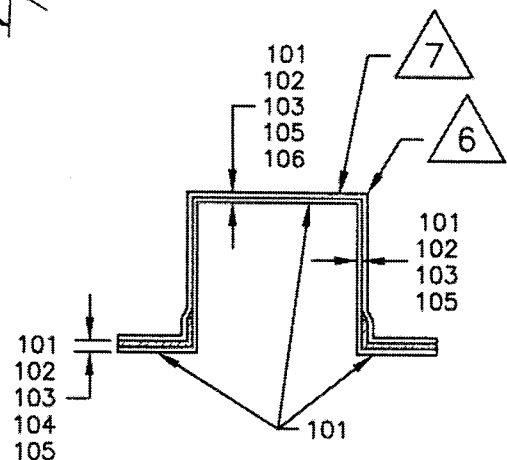
DESIGN	JB	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	DRAWING NO. D2273 REV. D SHEET 1 OF 1
DATE	02.04.01	TITLE	350 REAR LOCKER EXTENDER SCALE NTS
B	96.05.27	RE-DRAWN	
C	02.01.30	CLARIFY MATERIAL, LAYUP, AND TOOLING	
D	02.04.01	REMOVE EPOCAST, ADD SURFACE FINISH	

RELEASED
02.04.03



NOTES:

- 1) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.
- 2) LAYUP USING DT8010 MOLD. WET LAYUP NO BAG/VACUUM.
- 3) TRIM & DRILL PER DT8020. OPEN HOLES TO $\phi 0.257$ (4 PLACES).
- 4) MATERIALS:
RESIN: DERAKANE 470-36/411/510A40
FIBRE: 9oz = 9.7 oz 7781 WEAVE "S" GLASS
18oz = 18.0 oz ROVING "E" GLASS.
- 5) CONSTRUCTION:
101-WHITE GLOSS GELCOAT # GEL 944W005.
102-9oz ALL OVER.
103-18oz ALL OVER.
104-18oz RE-INFORCE FRONT FLANGE EXTENDING 2" ON SIDES.
105-9oz ALL OVER.
106-PEEL PLY.
- 6) MATTE TO HOLD DOWN CORNERS AS REQUIRED.
- 7) FINISH THIS SURFACE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S.
- 8) ALL DIMENSIONS ARE IN INCHES.



SECTION A-A

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	41840
Customer #	DART US

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

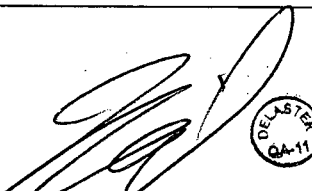
Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
FEDEX P1 Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
16/01/2012	06/12/2011	19467	Chantal Lavoie		PO15600		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0003	Rear Locker Extender D350-604-041P B77301 Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D <div><div><u>No. série</u> B77301</div><div><u>No. lot</u> 37644</div></div> <div>U de M : Each</div>			
1	0	1	DKC134-0003	Rear Locker Extender D350-604-041P B77302 Référence DKA362-0004 DWG: D350-604-041 REV. A1 D2273 REV. D <div><div><u>No. série</u> B77302</div><div><u>No. lot</u> 37035</div></div> <div>U de M : Each</div>			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:


Quality department

AQ-357

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Mardi, 2011-11-08 12:49:33
 Utilisateur: Pascal Carignan

Feuille de Procédé

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: REAR LOCKER EXTENDER
Numéro Job	: 37035	Numéro Article	: DKC134-0003
Numéro Soumission	: 3482	Numéro Dessin	: D350-604-041 & D2273
Numéro B.A.	:	Projet Numéro	: DK-362
Cette fois	: 2011-11-08 No. B.V. :	Révision dessin	: A & D
Prsht Rev.	: NC	Matériel	: Derakane 470-36/411/510
Prem. fois	: Type :	Date Dûe	: 2011-11-15 Qté: 1 Udm: UNITE
Job précédente	: 37034		
Écrit par	:		
Vérifié & Approuvé par	:		
Commentaires	: N° de pièce Laminée Dart Aerospace: D2273		
	: N° de pièce Assemblage Dart Aerospace: D350-604-041		

B 77302

Process Sheet Rév.: 03 Modifier la seq. 6 Prep-general.

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 PRÉPARATION Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire la préparation du moule DKO-0250 selon IG 0009.

Date: 9/10/12 Sceau: 

2.0 AMB0350 Gel Coat Blanc N° Gel 944W005

 Commentair Qty.: 1.580 UNITE(s)/Unit Total : 1.580 UNITE(s)
 Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-33488-1

3.0 AMB0286 Catalyst N° DDM-9

 Commentair Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)
 Catalyst N° DDM-9 N° de Lot: 1-27829-1

4.0 AC0747 Acetone


Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)

5.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler le matériel selon les dimensions requises à l'aide de gabarit de trimage prévus à cet effet.

Date: 10 Nov 11 Sceau: 

Date: Mardi, 2011-11-08 12:49:33
Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 37035

Nom Dessin: REAR LOCKER EXTENDER
Numéro Article: DKC134-0003

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

6.0	PREP-GENERAL	Préparation du matériel
-----	--------------	-------------------------



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire la préparation du Gel coat selon IF134-0003 .

Date: 9/01/12 Sceau: 


7.0	GEL COAT	Application du Gel Coat
-----	----------	-------------------------



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Appliquer le gel coat selon IF 134-0003(réf. IG0019).

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Quantité: 1 Date: 9/01/12 Sceau: 

8.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
-----	---------	---

Commentaire Qty.: 1.680 LITRE(s)/Unit Total : 1.680 LITRE(s)
Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-33579-1

9.0	AMB0286	Catalyst N° DDM-9
-----	---------	-------------------

Commentaire Qty.: 0.0070 GALLON(s)/Unit Total : 0.0070 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

10.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
------	---------	---

Commentaire Qty.: 4.6 VERGE(s)/Unit Total : 4.6 VERGE(s)
9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: 1-31000-2

11.0	AMB0213	WR1850 Roving 18oz. x 50"
------	---------	---------------------------

Commentaire Qty.: 1.140 KILOGRAMME(s)/Unit Total : 1.140 KILOGRAMME(s)
WR1850 Roving 18oz. x 50" N° de Lot: 1-32516-1

12.0	LAMINAGE	Faire le laminage
------	----------	-------------------





Commentaire Setup: 0.00Hrs/ Run: 3.5000Hrs Total Run : 3.5000Hrs

Selon IF 134-0003. S'assurer de ne pas trapper d'air entre les rangs.

Inscrire les informations suivantes:

Humidité: 23% Température: 77°F Heure: 12:45

Quantité: 1 Date: 9/01/12 Sceau:  

Date: * Mardi, 2011-11-08 12:49:33

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 37035

Numéro Article: DKC134-0003

Numéro Job:



Séq.: Machine ou Opération: Description :

13.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.150 LITRE(s)/Unit Total: 0.150 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot: 1-33579-1

14.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0070 GALLON(s)/Unit Total: 0.0070 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

15.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Injecter les bulles d'air selon IF134-0003 si applicable.

Quantité: _____ Date: _____ Sceau: _____

16.0 DÉMOULAGE Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire le démoulage de la pièce selon IF134-0003 en poussant de l'air à l'intérieur tout en faisant bien attention de ne pas l'endommager.

Quantité: 1 Date: 10/01/12 Sceau: _____



17.0 TRIMAGE Trimage



Commentair Setup: 0.00Hrs/ Run: 40.0000Min Total Run : 0.6667Hrs

Selon IF 134-0002.

Faire le sablage si nécessaire.

Quantité: 1 Date: 12-01-12 Sceau: _____



18.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.3400 UNITE(s)/Unit Total: 0.3400 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-3117-3

19.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0670 UNITE(s)/Unit Total: 0.0670 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-31394-2

Date: Mardi, 2011-11-08 12:49:33

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 37035

Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:

Description :

20.0

PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Appliquer le primer selon IG 0008.



Quantité: 1

Date: 12/01/12

Sceau:

N° fiche de Mélange: N/A

21.0

AAC1607

Camlock Stud 2600-4 (or Monadnock 1126000-4)

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)

Camlock Stud 2600-4 (or Monadnock 1126000-4)

N° de Lot: 1-33626-1

22.0

AAC0682

Washer 2600-LW (1127700)

Commentair Qty.: 4 UNITE(s)/Unit Total : 4 UNITE(s)

Washer 2600-LW (1127700)

N° de Lot: 1-32667-6

23.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'assemblage selon IF134-0004.

Démasquer la pièce.

Assembler les "Studs" selon IG 0037.

Quantité: 1

Date: 13-01-12

Sceau:



24.0

IDENTIFICATION

Identification à encre indélébile



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'identification de la pièce selon IF134-0005.

N° de pièce Cleint: D350-604-041

N° de Job: 37035

N° de Fabrication: 01/13/12

Quantité: 1

Date: 01/13/12

Sceau:



25.0

INSPEC FINAL

Inspection finale



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Date: Mardi, 2011-11-08 12:49:33

Utilisateur: Pascal Carignan

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: REAR LOCKER EXTENDER

Numéro Job: 37035

Numéro Article: DKC134-0003

Numéro Job:



Séq.:

Machine ou Opération:



Description :

Quantité: 1 Date: 16-01-12 Sceau:

26.0

EMBAL / ENTREPO

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'emballage selon IG 0057.

Quantité: 1 Date: 16/01/12 Sceau:

